

Work Order ID 84825

Wednesday, May 23, 2012 7:23:44 PM

84825

Page 1

Item ID: D4016-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Light Lid

Start Date: 5/23/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/23/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4016	A
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100 Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK as per folio

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA874 AND DWG

FOLIO REV: _____

DWG REV: _____

DEBURR

Manual Mill

12-5-24

12-5-24

84825

Wednesday, May 23, 2012 7:23:44 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/23/2012 **Start Qty:** 3.00 ***3***

Cust Item ID:

Required Date: 5/23/2012 **Req'd Qty:** 3.00 ***2***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

**Accept
Qty**

Reject Qty

Reject
Number

**Insp.
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0,00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: W/A

0.00

160

Packaging

Memo

0.00

Packaging

Work Order ID 84825***84825***

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Wednesday, May 23, 2012 7:23:44 PM

Item ID: D4016-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Half, Light Lid

Start Date: 5/23/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/23/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/5/29
MCS 12/05/28

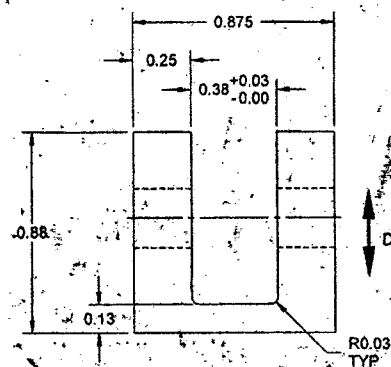
Wednesday, May 23, 2012 7:23:43 PM

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY:DD IPP Rev:B as per dwg REV.A DD
10.02.22 verified by:EC

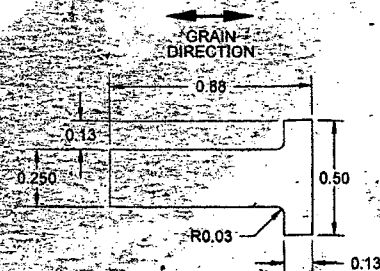
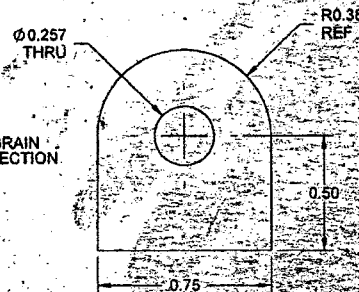
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT002	8.58	
114993	4.58	
119346	4	
MAT003	26.65	
119801	2.65	
121836	24	

_____ 32 12-5-24

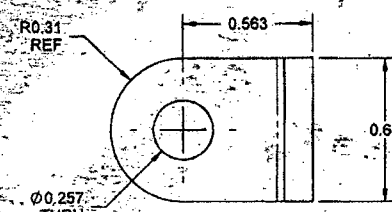




D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4016	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET HINGE	NTS
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